

Date: Friday, 30/05/2008 10:13:10 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: OUTER FWD SADDLE		
<b>Job Number</b>	: 39603			<b>Part Number</b>	: D5951		
<b>Estimate Number</b>	: 11076			<b>Drawing Number</b>	: D5951 REV.B		
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A		
<b>This Issue</b>	: 30/05/2008 <b>S.O. No.</b> :			<b>Drawing Revision</b>	: B		
<b>Prsh Rev.</b>	: NC			<b>Material</b>	:		
<b>First Issue</b>	: / / <b>Type</b> : MACHINED PARTS			<b>Due Date</b>	: 15/06/2008 <b>Qty:</b> 6 <b>Um:</b> Each		
<b>Previous Run</b>	: 39196						
<b>Written By</b>	:						
<b>Checked &amp; Approved By</b>	<u>JLD 08-5-30</u>						
<b>Comment</b>	: Est Rev:E Re-Format 05-11-29 JLM Est Rev:E Re-Format 05-11-29 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101013	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)	
		D6101-013 (7075-T7351)	
		Size 2.50" x 10.10" X 8.25" (Grain along 10.10")	
		Batch: B38696	<i>DTP 08/06/07 (6)</i>
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3	
		Comment: HAAS CNC VERTICAL MACHINING #3	
		1-Machine as per folio D5951, Ensure Batch Number is entered	
		2-Machine Keyway	
		3-Deburr & Tumble	<i>DTP 08/06/07 (6)</i>
3.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<i>DTP 08/06/07 (6)</i>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>S 08/06/16 (6)</i>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Chemical Conversion Coat as per QSI 005 4.1	<i>FL 08/06/16 (6)</i>

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:13:10 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER FWD SADDLE

Job Number: 39603

Part Number: D5951

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M107925



(6X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:30

OVEN TEMPERATURE:

320

FINISH TIME:

2:00

m/f

08/06/16

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



40



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-06-16

(x6)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST421

88 08/06/17 (x6)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/18 (x6)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



1 08-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 391003

Description: Outer Fwd Saddle

Part Number: D5951

Inspection Dwg: D5951

Rev: B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.437	0.444		0.444	0.443	0.443	0.443		
B	1.745	1.755		1.749	1.749	1.750	1.749		
C	5.245	5.255		5.249	5.249	5.250	5.251		
D	6.995	7.005		7.000	7.000	7.001	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.749	4.749	4.749	4.750		
G	0.315	0.322		0.322	0.322	0.322	0.322		
H	1.522	1.532		1.526	1.527	1.527	1.526		
I	3.048	3.058		3.051	3.052	3.053	3.052		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.322	0.322	0.322	0.322		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.505	0.501	0.501	0.505		
N	1.615	1.635		1.626	1.625	1.625	1.624		
O	7.990	8.010		8.001	8.001	8.000	8.000		
P	2.240	2.260		2.250	2.248	2.248	2.249		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.502	0.503	0.504	0.503		
T	1.375	1.395		1.3865	1.386	1.3875	1.389		
U	2.000	2.020		2.000	2.0035	2.006	2.0065		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	
Date:	08/06/07

Audited by:	
Date:	08/06/07

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.12.06	Dimensions A,G,K,L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	

DART AEROSPACE LTD	Work Order:	39603
Description: Outer Fwd Saddle	Part Number:	D5951
Inspection Dwg: D5951	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	3	4	By	Date
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B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.245	5.250				
D	6.995	7.005		6.999	7.000				
E	5.240	5.260		5.250	5.250				
F	4.745	4.755		4.749	4.749				
G	0.315	0.322		.322	0.322				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.053	3.053				
J	4.575	4.585		4.580	4.580				
K	0.315	0.322		0.322	.322				
L	0.495	0.505		0.500	0.500				
M	0.490	0.510		0.4995	0.499				
N	1.615	1.635		1.624	1.623				
O	7.990	8.010		8.000	8.000				
P	2.240	2.260		2.248	2.247				
Q	0.307	0.312		0.310	0.310				
R	0.760	0.765		.760	.760				
S	0.490	0.510		.495	0.499				
T	1.375	1.395		1.3855	1.3855				
U	2.000	2.020		2.0045	2.004				
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	DTP	Audited by:	
Date:	08/06/09	Date:	08/06/09

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
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E	08.04.21	Dimension E revised	KJ/DD	

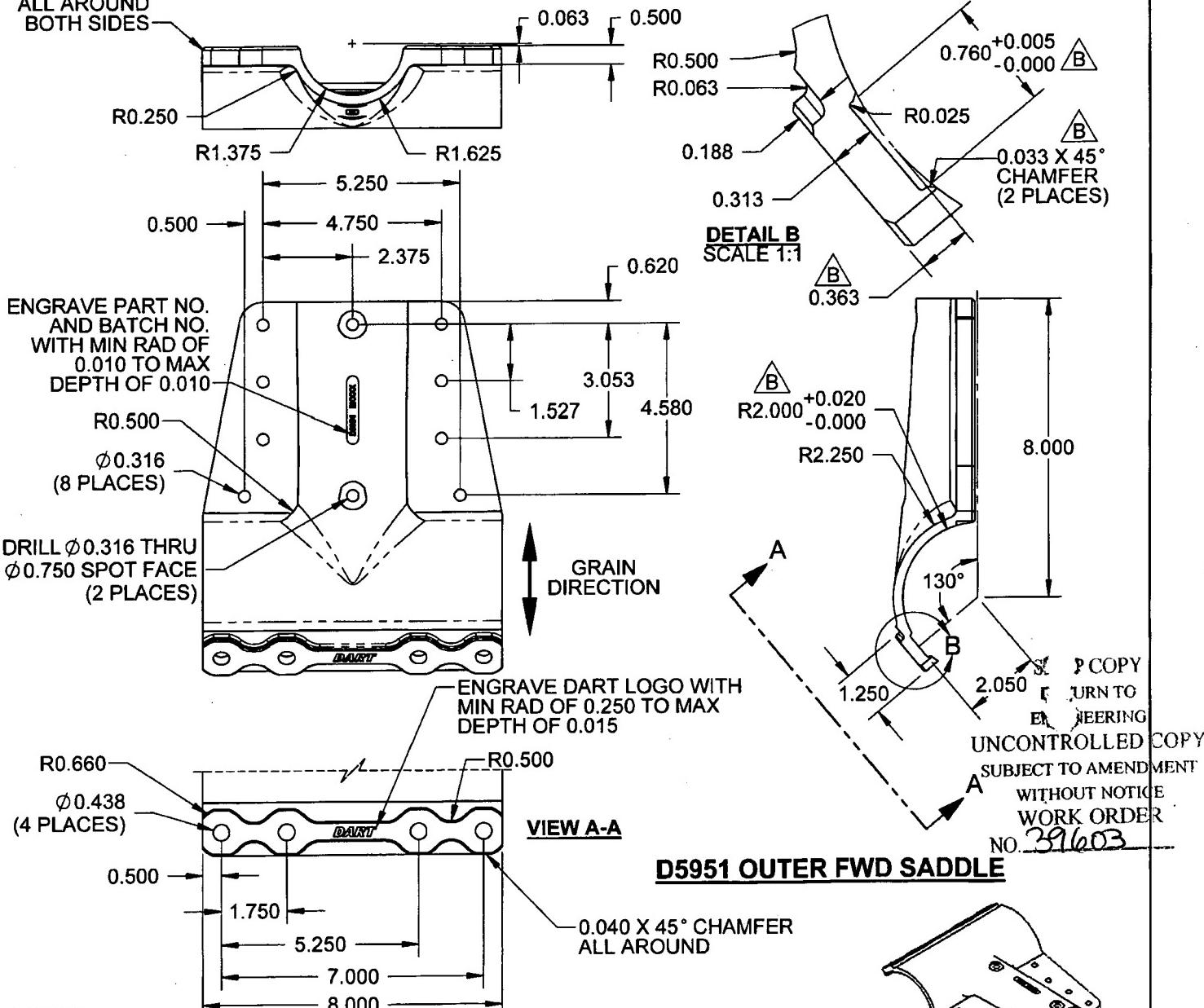
**DART**

DESIGN BW	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D5951	REV. B SHEET 1 OF 1
DATE 06.11.07		TITLE OUTER FWD SADDLE	SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
REV B	DATE 06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM;	

RELEASERED

06.11.28

CHAMFER  
0.075 X 45°  
ALL AROUND  
BOTH SIDES



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